



## ***Product Data Sheet***

### **EP-76** **Epoxy Bonding Adhesive**

#### **DESCRIPTION**

EP-76 Epoxy Bonding Adhesive is a two component epoxy bonding resin. It is designed to bond Precision Board to itself to make longer, wider, or thicker pieces, sheets, or blocks. EP-76 A & B kit comes with a separate container of PB Granules to allow variable consistency and ease of machining.

EP-76 will not shrink, can be machined, drilled, tapped, sawed, and feathered to a zero edge. It contains no metallic fillers, is a non-conductor of electricity, and will not promote electrolysis. EP-76 is suitable for interior and exterior exposure.

The consistency of EP-76 can be adjusted using PB-Granules to allow bonding of both horizontal and vertical surfaces. i.e.: edge bonding and sheet laminating.

The durometer hardness and machinability of EP-76 can be adjusted and closely matched to the Precision Board densities listed by adding PB Granules as indicated.

#### **Application**

Mix ratio of A to B is: 27 parts A to 100 parts B.

Mix part A and part B thoroughly to assure proper curing. EP-76 is completely mixed when all streaks of color disappear. Allow ample mixing time to be sure mix is complete since without it EP-76 will not cure – ever. Add desired percentage of PB Granules after A&B have been completely mixed.

Ratio of PB Granules to mixed A&B for both PBLT & PBHT is:

PB-20 = 28% PB Granules (of combined A & B weight)

PB-30 = 22% PB Granules

PB-40 = 10% PB Granules

Surfaces to be bonded must be dry and clean. To increase bond strength, prime entire tool surface with EP-76 thinned with 50% acetone. Don't add PB Granules for this application. Wipe thinned EP-76 on and then wipe off. Allow to completely cure.

Apply EP-76 to mating surfaces with putty knife or squeegee. Force material into the surface to guarantee total surface wet out and maximum bond strength.

Pot life (working time for 100 grams) is about 60 minutes at 75° - 80°F. Lower or higher ambient temperatures will slow it down or speed it up.

Cure time of EP-76 is complete in 24 hours.

**NOTE:** For questions regarding use of EP-76, please contact Coastal Enterprises at (800) 845-0745.

**CAUTION:** Use with adequate ventilation. Avoid breathing vapors. Avoid all contact with eyes and skin. May cause eye damage and severe skin irritation. Close containers after each use. Do not take internally. **KEEP OUT OF REACH OF CHILDREN.**

**WARRANTY:** All recommendations for product use have been derived from experience and test data believed to be reliable. We warrant and guarantee the uniformity of our products within manufacturing tolerance. However, since the use of our products are beyond our direct control, they are furnished upon the condition that each party shall make his/her own tests to determine their suitability for his/her particular purpose. Except as stated herein, Coastal Enterprises Company makes no warranty or guarantee, expressed or implied, and disclaims all responsibility for results obtained, nor assumes any liability for any damages, whether arising out of negligence or breach of guarantee and is hereby expressly limited to replacement of product only. For additional information on product handling, please refer to PB Bond-240 MSDS